

Work Order ID 80256

80256

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Item ID: D2803-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 15/02/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2803	Rev B

100 0.00
 100 Small Fab
 Small Fab Memo 0.00
 Small Fab Press D2805-1 and D2809 into arm as per Dwg D2803

110 0.00
 110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

120 0.00
 120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Powdercoat Memo 0.00
 Powder Coating

START TIME: 1600 OVEN TEMPERATURE: M120 222
 FINISH TIME: 1630 320°F

12/03/29

45
041

5 Q OP 12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D2803.								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

5 Bl 12 329

EP 12/03/29 (5)

(5)
-08/

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>144</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/2

12-03-3d

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80256

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Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1 *D2803-1* Bracket		Manufactured	No			100	Each	13.0000	1	5		15/02/2012	
**													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST148			13						
				75079			1						
				79081			8						
				79177			4						
D2805-1 *D2805-1* Stop		Manufactured	No			100	Each	24.0000	1	5		15/02/2012	
**													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			24						
				79525			24						
NAS1515H3 *NAS1515H3* Washer		Purchased	No			100	Each	286.0000	4	20		15/02/2012	
**													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST277			286						
				118078			6						
				118384			11						
				119438			4						
				120142			99						
				120518			166						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 80256

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Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN3C16A

Purchased

No

150

Each

109.0000

2

10

AN3C16A

Bolt

**

EP 12/03/29

Location

Loc Qty

Loc Code

ST352

109

115835

1

118422

4

119641

4

120498

100

10

D2809

Manufactured

No

150

Each

23.0000

1

5

D2809

Bushing

**

EP 12/03/29

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

16

34035

12

77292

4

B80557
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80256

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Parent Item: D2803-041

D2803-041

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21043-3

Purchased

No

150

Each

1,340.000

2

10

MS21043-3

Nut

[Signature]
2/23/29

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

400

120693

400

ST300

373

119901

373

ST301

495

118077

2

118614

441

118686

30

119758

22

10

W/O:		WORK ORDER CHANGES					
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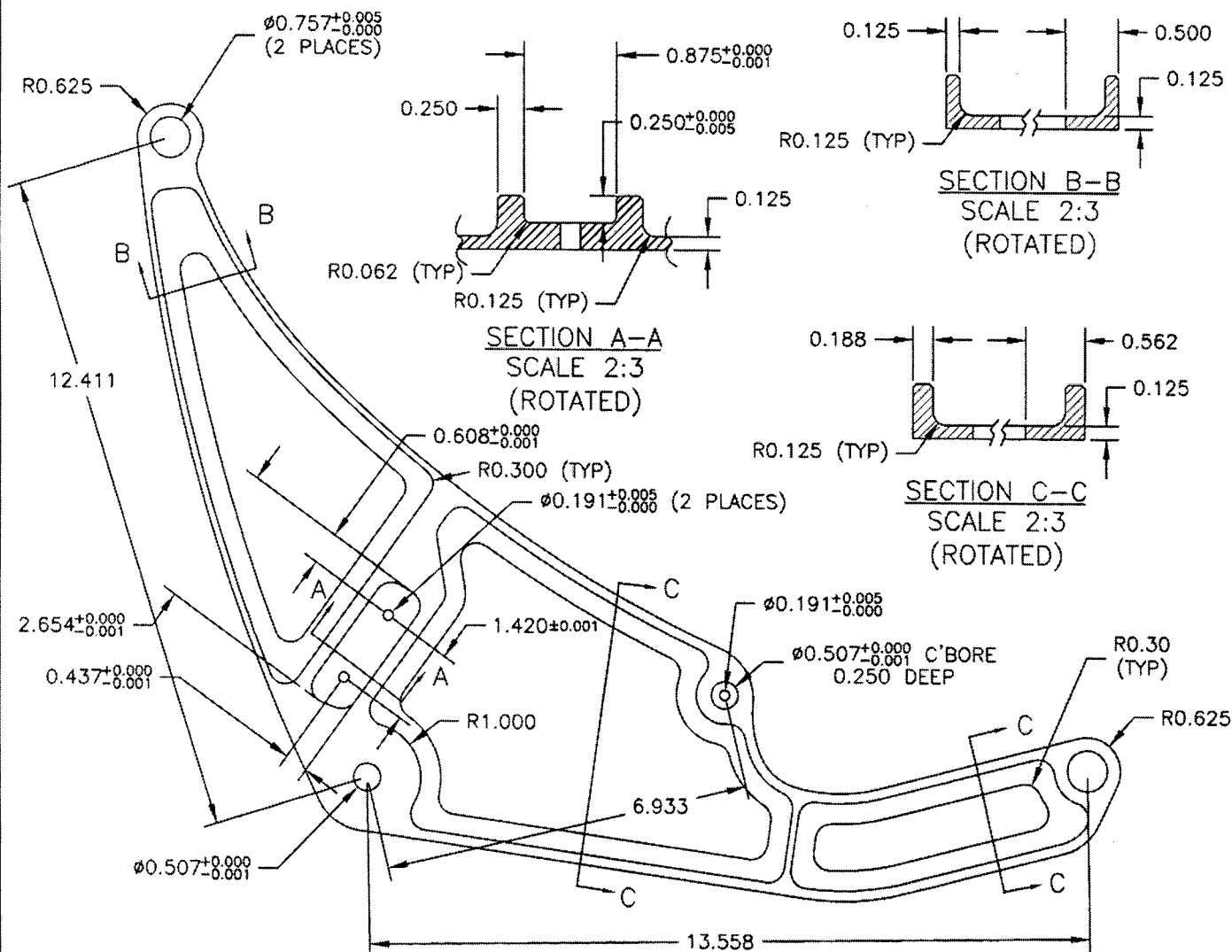
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03-11 *[Signature]*



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 80256

M.C.J

12/02/06

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

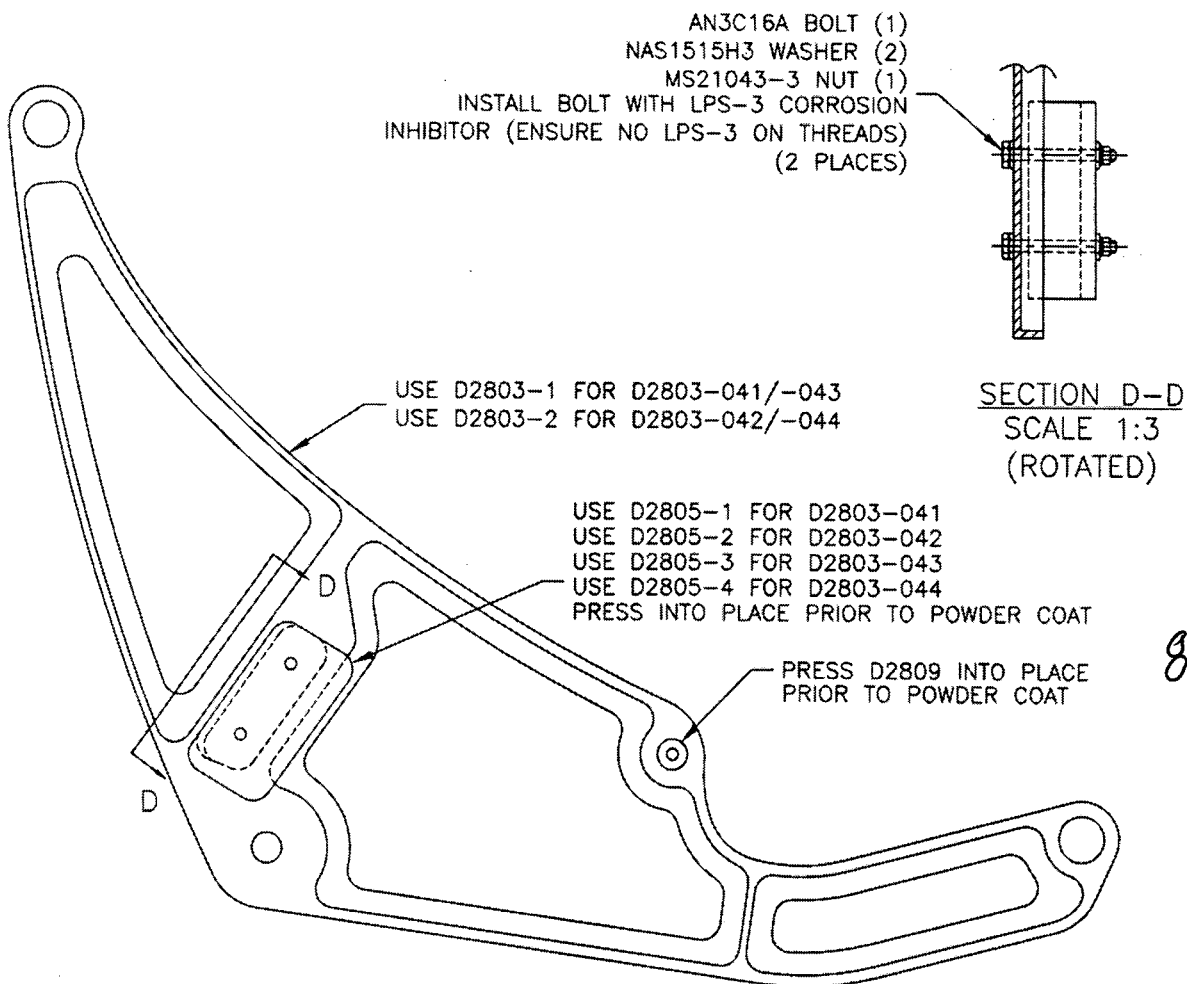
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03.11 H

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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